

Work Order ID 53351

November 2, 2009 10:42:15 AM

Blue



SPLIT-2

Page 1

Item ID: D3407-043

Accept

Setup Start

Revision ID: E

Stop

Item Name: Tow Ring

Start Date: 02/11/2009 Start Qty: ~~20.00~~ 4

Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 20.00

Customer:

Reference:

Approvals: Process Plan: PL Date: 09-11-2 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3407	Rev E

100



Large Fab

Large Fab

0.00

Memo

0.00

Large Fab

Weld D3407-3/-5 using welding rod TIG174 as per Dwg D3407 & QSI
004 A/R TIG174 ROD Batch: M/01972

Cpl 09 11 09

110



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

09.11.10 20

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

20 09.11.10

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Page 2

Item ID: D3407-043

Accept



Setup Start



Revision ID: E

Stop



Item Name: Tow Ring

Start Date: 02/11/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

125

Spray Painting per QSI005 4.2

0.00



SprayPaint

Memo

0.00

Spray Painting

Prime B 110199

Spray Paint Delfleet Blue B 113171

Clear Delfleet B 113033

09 11 16 (4)

135

QC14- Inspect Spray Paint

0.00



QC

Memo

0.00

Quality Control

09 - 11 - 17 (4)

150

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

12/9/12 (4)

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Page 3

Item ID: D3407-043

Accept



Setup Start



Revision ID: E

Stop



Item Name: Tow Ring

Start Date: 02/11/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/17
MF
09-11-17

Picklist Print

November 2, 2009 10:42:21 AM

Page 1

Work Order ID: 53351

Parent Item: D3407-043RevE

Parent Item Name: Tow Ring





Comments:

Start Date: 02/11/2009

Required Date: 13/11/2009

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3407-3RevE 		Manufactured	No			100	Each	0.0000	20.0000			
Stem D3407-5RevE 		Manufactured	No			100	Each	31.0000	20.0000			
Ring												

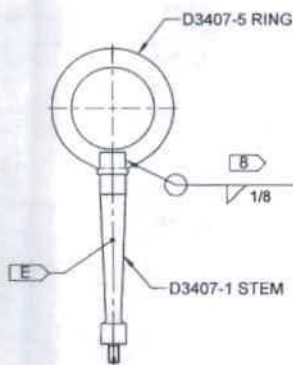
B53350 → (20) Cpl 09/11/09

Cpl 09-11-09

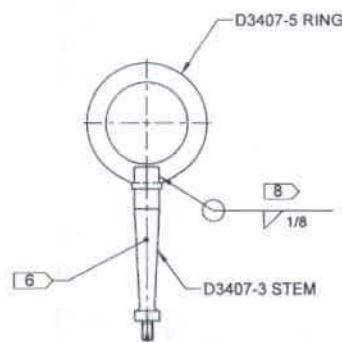
<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
WA	31	
51633	10	
52318	21	

*(10) ✓
(10) ✓*

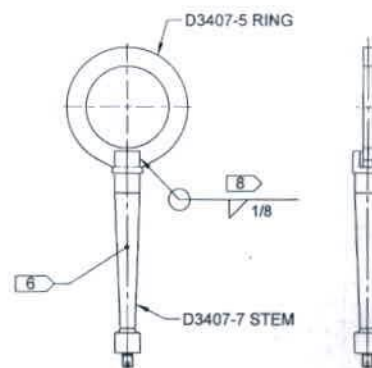
QTY -041	QTY -043	QTY -045	PART NUMBER	DESCRIPTION
X			D3407-041	TOW RING
	X		D3407-043	TOW RING
		X	D3407-045	TOW RING
1			D3407-1	STEM
	1		D3407-3	STEM
1	1	1	D3407-5	RING
		1	D3407-7	STEM



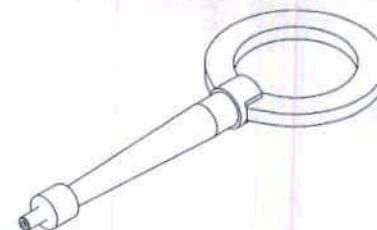
D3407-041 TOW RING



D3407-043 TOW RING



D3407-045 TOW RING



RELEASED
08-07-23

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3407-XXX" USING BLACK FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: D3407-041 - 0.60 lbs, D3407-043 - 0.53 lbs, D3407-045 - 0.61 lbs
 - 8) WELD PER DART QSI 004 ON ALL EDGES BETWEEN STEM AND RING

E

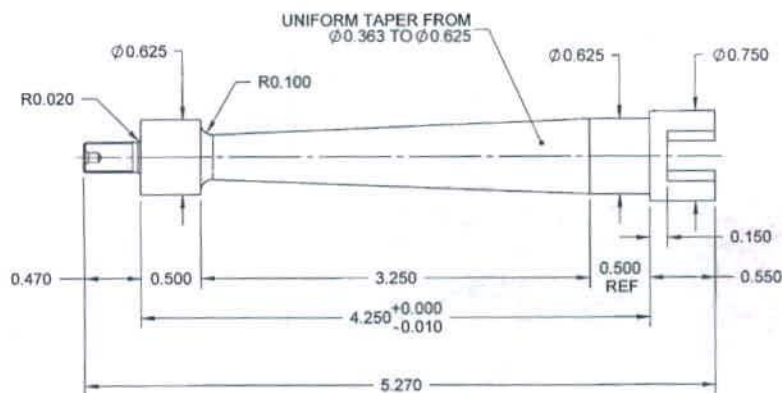
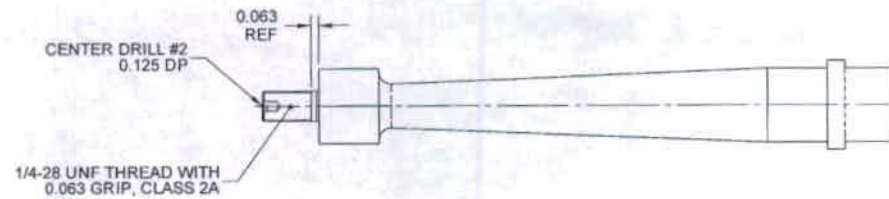
SUPPLY
REQUIRE
FOR WORK
UNCONTROLLED
SUBJECT TO
WITHOUT
WORK
NO 53351
BT 09-11-2

E	ADD D3407-045 (ZN B2-1, D8-1); ADD D3407-7 (ZN B6-5); REVISED NOTE 6 TO ADD IDENTIFICATION (ZN A8-1); REASON: PRODUCTION FACILITY	PH	08.07.23
D	D3407-1/3 SLOT WAS ROUND NOW FLAT FOR ASSEMBLY WITH D3407-5 (ZN C2-2, C3-3); D3407-5 WAS ROUND NOW FLAT ON ONE END FOR ASSEMBLY WITH D3407-1/3 (ZN B6-4); REASON: PRODUCTION FACILITY	PH	08.04.07
C	-1/3 LONGER FOR FIT W/WASHER	CP	05.09.09
B	UPDATE DIAMETER, THREAD CLASS ADDED	CP	05.06.17
A	NEW ISSUE	CP	05.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.07.23		

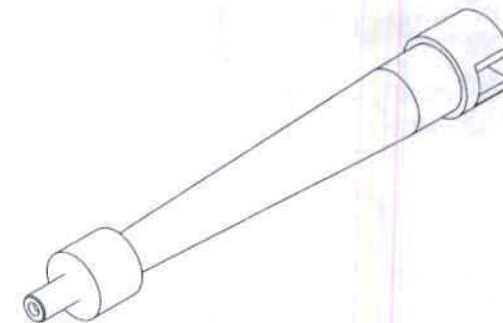
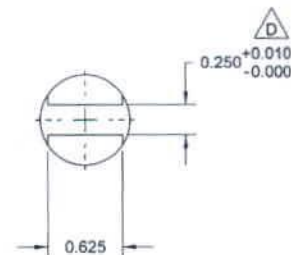
DART AEROSPACE USA, INC.
PORT HADLOCK, WA

DRAWING NO. REV. E
D3407 SHEET 1 OF 5
TITLE SCALE
TOW RING NTS

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D3407-1 STEM



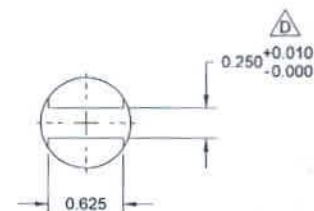
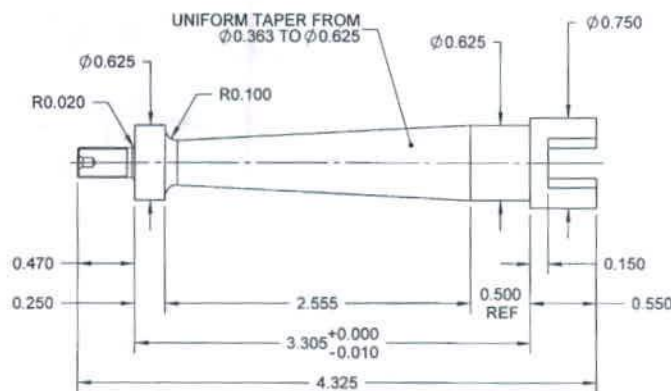
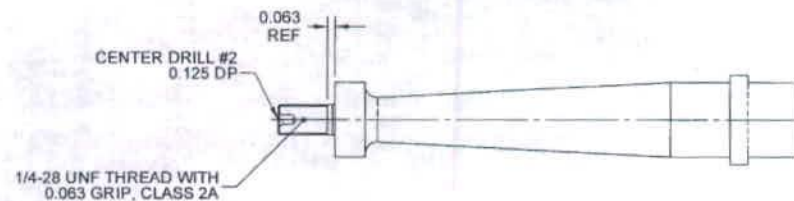
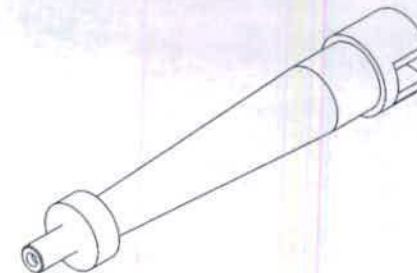
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WORK ORDER
NO. 53307

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08-07-23

- NOTES:
- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.33 lbs

DESIGN		DART AEROSPACE USA, INC.	
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CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3407	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		TOW RING	NTS
DATE	08.07.23	<small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. NO DISSEMINATION OR REPRODUCTION IS PERMITTED WITHOUT THE EXPRESS WRITTEN PERMISSION OF DART AEROSPACE USA, INC.</small>	

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W. T. D. 010101
W. T. D. 010101
NO. 53351



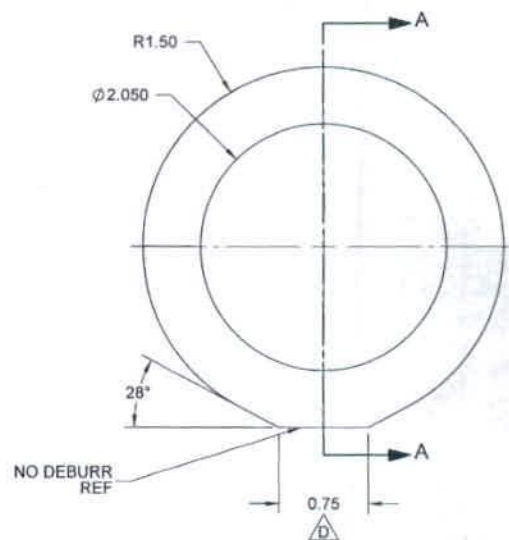
D3407-3 STEM

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08-07-23

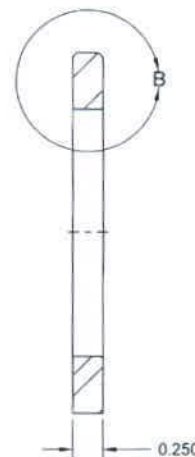
- NOTES:
- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.27 lbs

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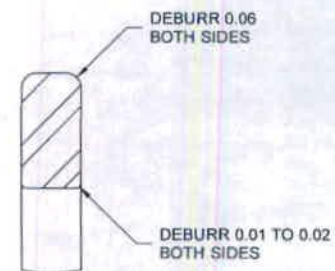
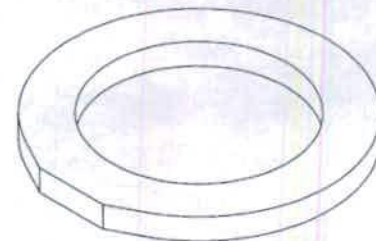
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D3407-5 RING



SECTION A-A



DETAIL B
SCALE 2X

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06-05-2118

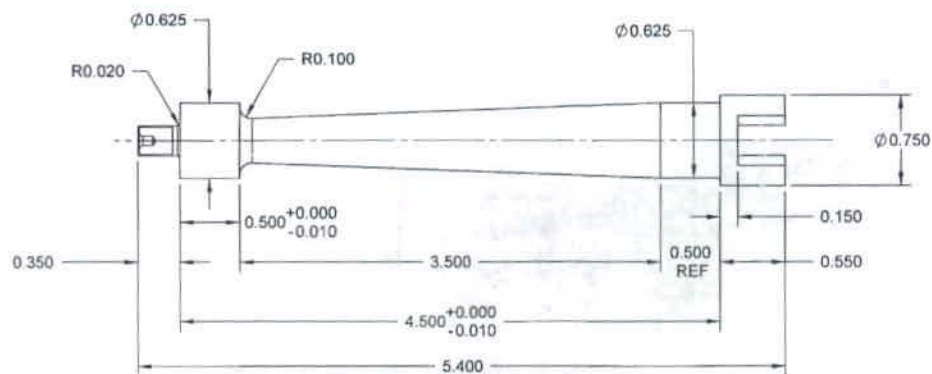
- NOTES:
- 1) MATERIAL: 17-4 PH SS BAR PER AMS 5604/5643 (REF. DART SPEC M17-4-B)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.27 lbs

DESIGN	92	DART AEROSPACE USA, INC.	
DRAWN	1/18	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3407	SHEET 4 OF 5
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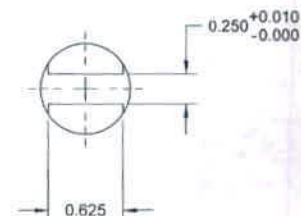
CENTER DRILL #2
0.125 DP

0.063
REF

1/4-28 UNF THREAD WITH
0.063 GRIP, CLASS 2A



D3407-7 STEM



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08-07-23

- NOTES:
- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES; MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.34 lbs

DESIGN	AJS	DART AEROSPACE USA, INC.	
DRAWN	IPF	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3407	SHEET 5 OF 5
APPROVED		TITLE	SCALE
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